

Date: Monday, 22/12/2008 2:05:21 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 BEARPAW  
 Job Number : 44221A  
 Estimate Number : 12480  
 P.O. Number :  
 This Issue : 22/12/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D35291  
 Drawing Number : D3529 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 First Issue : 11 Type : MACHINED PARTS  
 Material :  
 Previous Run : 43833 Due Date : 20/01/2009 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : MF 08-12-22  
 Comment : Est Rev:A New Issue 06-06-28 JLM  
 Est Rev:B New Manufacturing Method 08-11-27 Verified By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MUHMBW10 UHMW 1" Black



Comment: Qty.: 1.3283 sf(s)/Unit Total: 10.6260 sf(s)

Material: Black UHMW 1"(MUHMBW10)

Batch: 109186 B 9-1-12

(8)

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING  
 Program Batch Number

07-01-12

3.0 WATER JET FLOW WATER JET



A B 9-1-12



Comment: FLOW WATER JET  
 CUT BLANK AS PER FILE D3529-1BLANK

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

J.L. 09/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 44221A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/01/16

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/16 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 44221

R 09/01/20 (8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21

Job Completion



MR 09-01-20

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DART AEROSPACE LTD		Work Order:	44221A
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.500	✓			
B	0.07 x 45°	+/-0.030 x 0.5°	0.080 x 45°	✓			
C	R0.25	+/-0.030	0.250	✓			
D	0.250	+/-0.010	.255	✓			
E	0.625	+/-0.010	.630	✓			
F	0.950	+/-0.010	.955	✓			
G	1.63	+/-0.030	1.620	✓			
H	12.14	+/-0.030	12.140	✓			
I							
J	5.70	+/-0.030	5.700	✓			
K	0.375	+/-0.010	.379	✓			
L	0.525	+/-0.010	.526	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	.130 x 45°	✓			
N	R0.50	+/-0.030	0.500	✓			
O	12.76	+/-0.030	12.760	✓			
P	3.38	+/-0.030	3.380	✓			
Q	3.75	+/-0.030	3.751	✓			
R	5.187	+/-0.010	5.189	✓			
S	5.25	+/-0.030	5.248	✓			
T	7.13	+/-0.030	7.131	✓			
U	Ø0.260	+0.006/-0.001	.260	✓			
V	0.30	+/-0.030	.315	✓			
W	0.93	+/-0.030	.925	✓			
X	1.30	+/-0.030	1.280	✓			

Measured by: JL	Audited by: J-F	Prototype Approval:	N/A
Date: 09/01/16	Date: 09/01/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

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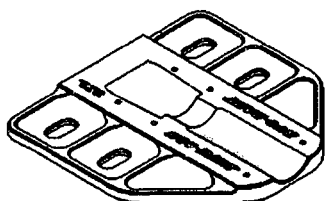
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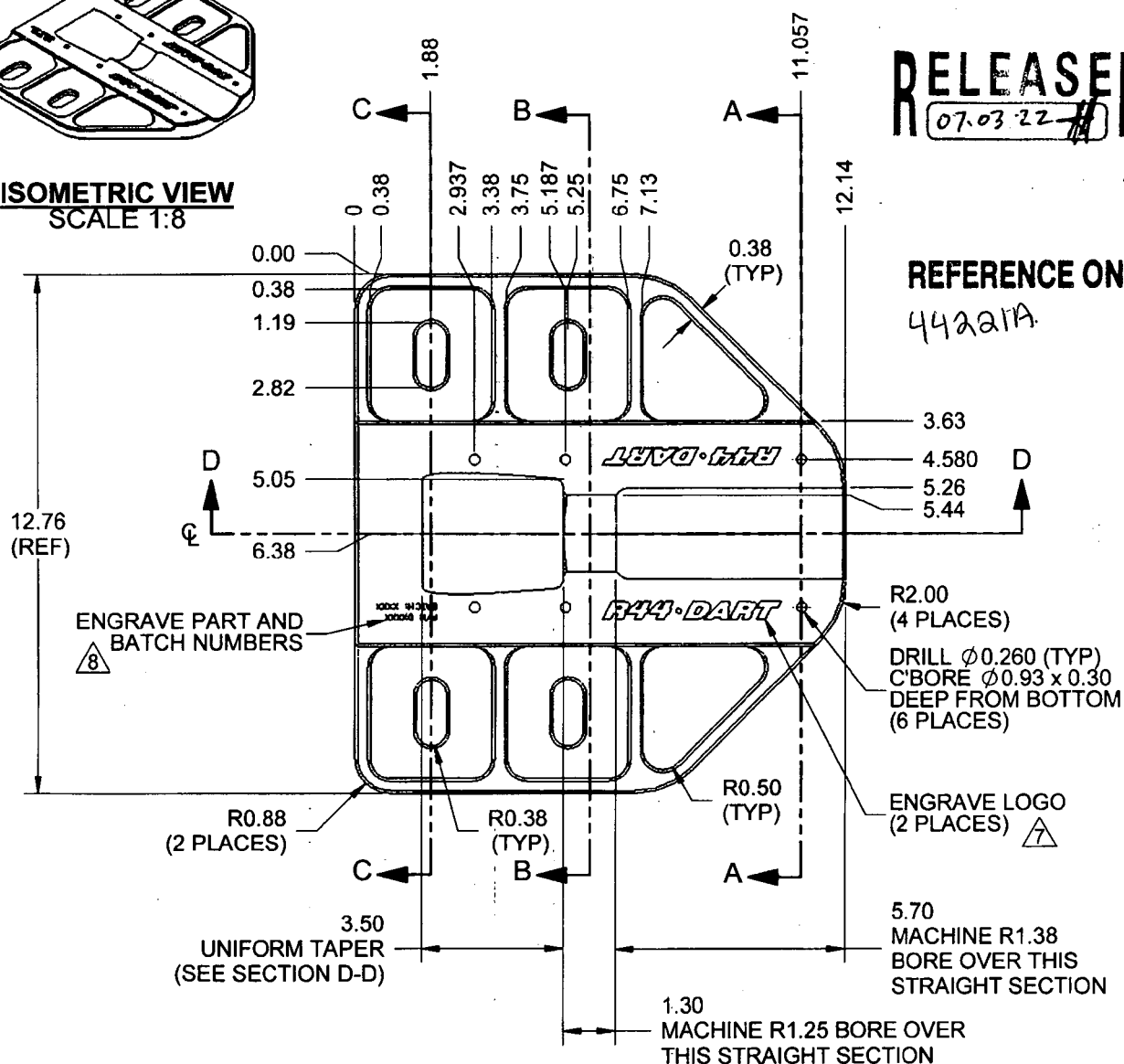
**NOTE:** Date & initial all entries



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3529</b>
DATE <b>07.01.04</b>	TITLE <b>R44 BEARPAW</b>	REV. A SHEET 1 OF 2
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE



**ISOMETRIC VIEW**  
SCALE 1:8



**D3529-1 R44 BEARPAW**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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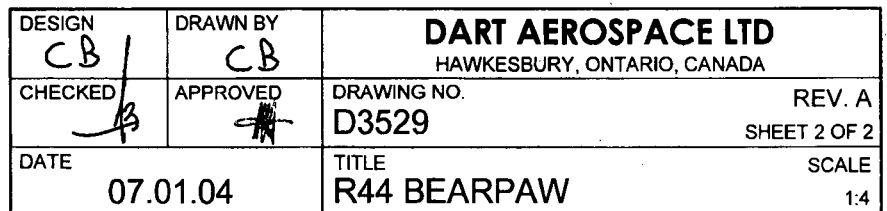
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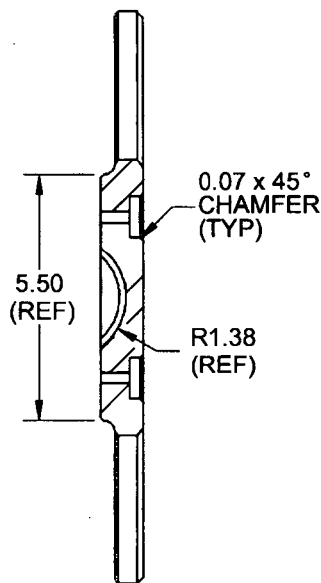
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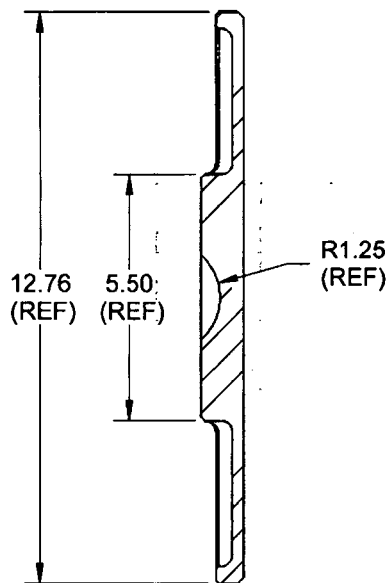




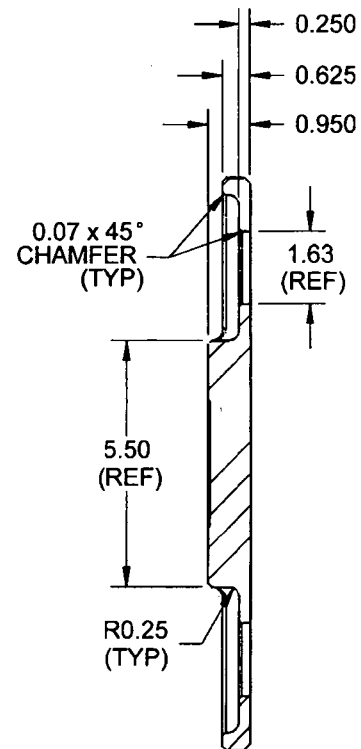
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07.03.22



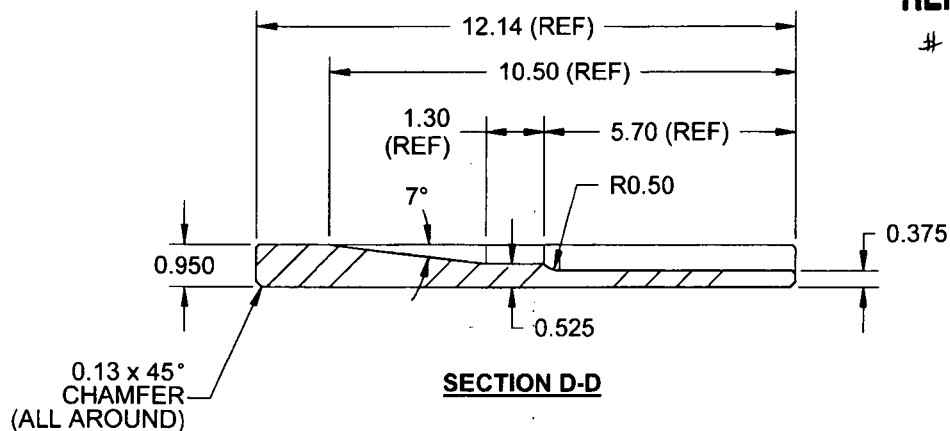
**SECTION A-A**



**SECTION B-B**



**SECTION C-C**



## SECTION D-D

**REFERENCE ONLY**

#44221A

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